

A. 624 W.063

## Work Order ID 68948



Page 1

Tuesday, April 26, 2011 10:42:18 AM

Item ID: D2743

Accept



Setup Start



Revision ID:

Stop



Item Name: Crossbolt Spacer

Start Date: 4/26/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 5/2/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan:

*H*

Date: 4/26/2011

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2743

Rev B

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA202 &amp; DWG D2743

FOLIO REV: *B*DWG REV: *B*

2-DEBURR AS REQUIRED

*SA 11/5/11**63*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*SA 4/5/11**63*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Start Date: 4/26/2011	Start Qty: 60.00		Cust Item ID:	
Required Date: 5/2/2011	Req'd Qty: 60.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		M.A 11/05/11		63	4		
130  Skidtubes Skidtubes	  Memo 1- Clean crossbolt spacer with ultra bright aluminum cleaner	0.00  0.00				63	0		BE 11/05/19
160  Packaging Packaging	Identify as per dwg & Stock Location: <u>LG</u>  Memo ***STOCK IN SKIDTUBE CELL***	0.00  0.00				63	0		BE 11/05/19

W/O:		WORK ORDER CHANGES					
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**Work Order ID 68948**

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Page 3

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Accept



Setup Start



Revision ID:

Stop



Item Name: Crossbolt Spacer

Start Date: 4/26/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 5/2/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/19

11-05-19  
(63)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

Tuesday, April 26, 2011 10:42:24 AM

Page 1

Work Order ID: 68948

Parent Item: D2743

Parent Item Name: Crossbolt Spacer



Start Date: 4/26/2011

Required Date: 5/2/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP ☐ E ☐ 05.04.13 ☐ Reformat; removed tumble and deburr step ☐ KJ/JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.625W.065		Purchased	No			100	f	6.0000	0.2667	16.84421			
6061-T6 RD Tube .625 x.065W													

Location

Loc Qty

Loc Code

MAT014

6

117328

6

117598

6A

12A



SA 11/5/11

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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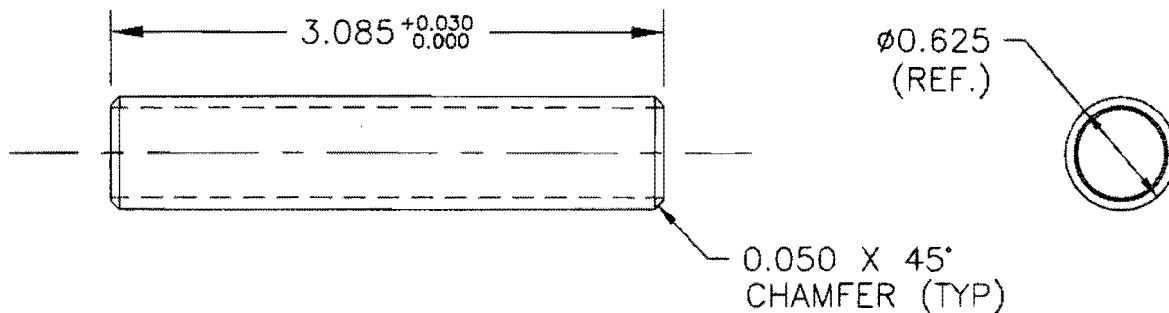
**NOTE:** Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>KE</i>	DRAWING NO. D2743	REV. B SHEET 1 OF 1
DATE 98.12.08		TITLE CROSS BOLT SPACER	SCALE 1:1
A	98.04.16	NEW ISSUE	
B	98.12.08	3.085 WAS 3.060	

RELEASED  
98.12.16 DS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68998



MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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